

Date: Wednesday, 6/28/2006 4:17:26 PM
 User: Kim Johnston

Process Sheet

| | | | | |
|-----------------------|-----------|-------------------------------|------------------|----------------|
| Customer | CU-DAR001 | Dart Helicopters Services | Drawing Name | : BUSHING |
| Job Number | 27738 | | | |
| Estimate Number | 10308 | | | |
| P.O. Number | N/A | | Part Number | : D26173 |
| This Issue | 6/28/2006 | S.O. No. : N/A | Drawing Number | : D2617 REV D2 |
| Prsht Rev. | NC | | Project Number | : N/A |
| First Issue | N/A | Type : MACHINED PARTS | Drawing Revision | : D2 |
| Previous Run | 24400 | | Material | : N/A |
| Written By | | See comment below | Due Date | : 7/22/2006 |
| Checked & Approved By | | KT 06 06 29 | Qty: | 20 |
| Comment | Est G | 04.07.14 | Um: | Each |
| | | Reformat; added step 5 KJ/JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|--|--|-------------|
| 1.0 | M6061T6T0375W058 | 6061-T6 Tube .375 x.058W | |
| | | | |
| | Comment: Qty.: 0.0765 f(s)/Unit Total : 1.5309 f(s) 6061-T6 Round Bar 1.5" Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) Batch: M19051 | | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL | |
| | | | |
| | Comment: HARDINGE Turn as per Folio FA437 and Dwg D2617 | N/A Machined Manually | 06/07/19 22 |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | | |
| | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | 06/07/19 22 |
| 4.0 | QC8 | SECOND CHECK | |
| | | | |
| | Comment: SECOND CHECK | | 06/07/19 22 |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | | |
| | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 | | 06/07/19 22 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 06/07/124

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Wednesday, 6/28/2006 4:17:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27738

Part Number: D26173

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/20 22

7.0 QC5

INSPECT WORK TO CURRENT STEP



JUL 07 21 22

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST53

SL 06/07/21 22

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DK 06/07/24 22

Job Completion



X 06.07.21

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector | |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27738 |
| Description: Bushing | Part Number: | D2617-3 |
| Inspection Dwg: D2617 | Rev: D2 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|---|-------------|---|---------------------|-----|
| Measured by: |  | Audited by: |  | Prototype Approval: | N/A |
| Date: | 06/07/19 | Date: | 06/07/19 | Date: | N/A |

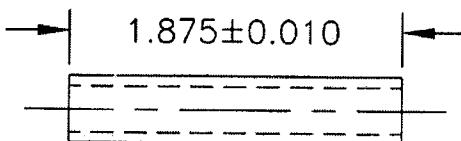
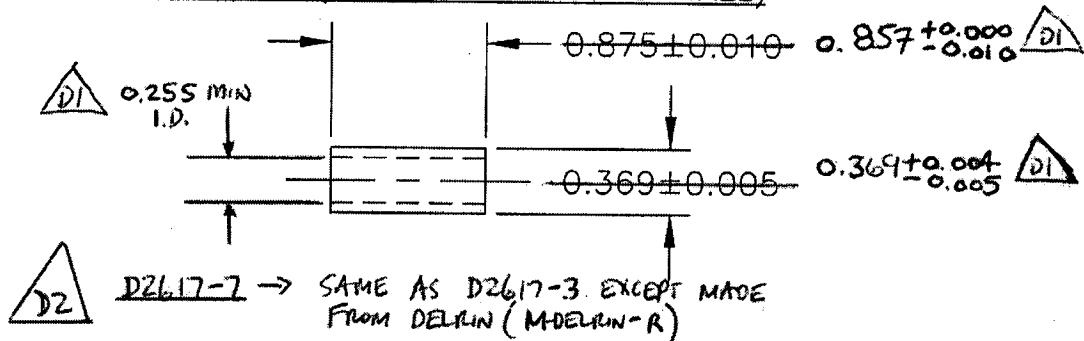
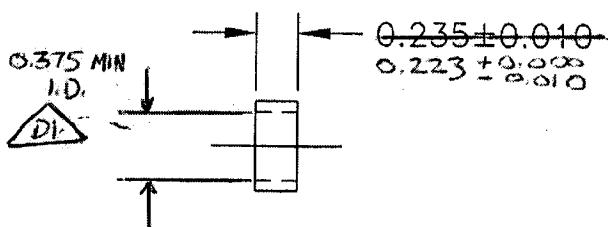
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------|------------|--------------------|
| A | 04.08.09 | New Issue | KJ/JLM | |
| B | 06.03.08 | Dwg Rev change | KJ/JLM | <i>[Signature]</i> |

DART

| | | | | |
|---------|-------------|-------------|----|---|
| DESIGN | BW | DRAWN BY | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | # | APPROVED | CP | DRAWING NO. D2617 REV. D SHEET 1 OF 1 |
| DATE | 01.07.04 | | | SCALE 1:1 |
| | | | | |
| D2 | 04.09.10 CP | ADD D2617-7 | | |

D2 04.09.10 CP

ADD D2617-7

D2617-1 (0.375 OD x 0.058 WALL)D2617-3 (0.375 OD x 0.058 WALL)D2617-5 (0.500 OD x 0.058 WALL)
RELEASED
 01.07.05 CP
NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6) COPY
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
NO. 27738

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